

5/44

DART AEROSPACE LTD	Work Order:	24497
Description: 206 Extrusion Bending	Part Number:	D2620
Drawing: D2620 Rev. B	Qty:	30 36

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.10.12	30
2	LG	Bend D2600-1 extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio F008 Batch B20534	DP	05-11-21	36
3	LG	Cut Fwd end of tube as per Dwg D2620	DP	05-11-21	36
4	QC5	Inspect for Completeness on the W/O	BE	05-11-21	36
5	LG	Identify and Stock in LG Cell	DP	05-11-21	36
6	AC	Cost/Part: 34.01	SUC	05-11-22	36
7	DC	Close W/O 36.25 Inspect Level 21	LD	05/11/22	36

Rev	Date	Change	Revised By	Approved
A	97.12.03		BW	
B	98.09.09	Bending now in-house	KS	
C	99.06.04	Re-format, Added cut	DM	
D	02.07.26	Change Dwg to rev.B; Updated Location	RF	

RELEASED
02/08/15 RF

4001-160

RF
03.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

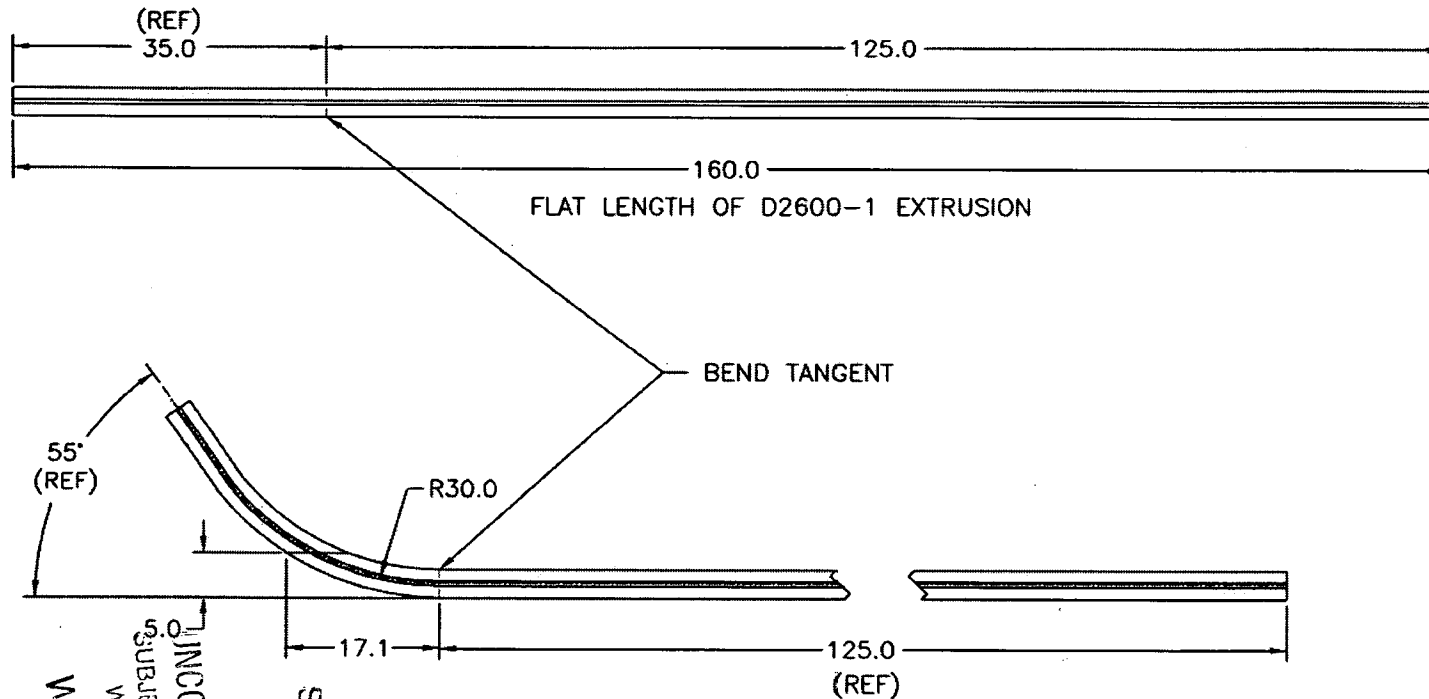
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 05/11/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING

RELEASED
49.04.15 DS

WORK ORDER
NO. 24497
SUBJECT TO INQUIRY
WITHOUT NOTICE
SHOF CO.
RETURN
ENGINEER

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 11, 2005
07:41 am

Work Order No	: 0024497	Department Code:	
Project Name	: D2620	Burden Flags	: NNNNNNNN
Project For	: WK544	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2620	Invoice Number	:
Description	: Bent 206 Skidtube	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 30	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-08-05		
Est Finish Date	: 11-05-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:20 pm

Work Order No : 0024497
Project Name : D2620
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2620
Description : Bent 206 Skidtube
Manufactured : Yes
Amount Req'd : 30
Amount Done : 0
Start Date : 10-08-05
Est Finish Date : 11-05-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.75	100.00		
Production Cost :	0.00	15.20	100.00	0.00	15.20
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	15.20	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	15.20			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-15.20)

MIS 0/B
u
11.13

Date: Monday, 14/11/2005 8:28:13 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 EXTRUSION BENDING
Job Number :	24497		
Estimate Number :	10311		
P.O. Number :		Part Number :	D2620
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2620 REV B
First Issue :	//	Project Number :	
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	LANDING GEAR	Due Date :	30/11/2005
Written By :		Qty:	30
Checked & Approved By :		Um:	Each
Comment :	Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001	Extrusion Round 3" 206
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2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion

